

Monday, July 14, 2014 1:55:26 PM

Page 1

Stop \*NR2\*

Draw Nbr	Revision Nbr
D4925	C

0.00

## FLOW WATER JET

## Waterjet

0.00

FLOW CNC Waterjet

## Memo

1-Cut as per Dwg D4925

Dwg Rev: C

Prog Rev:\_\_\_\_\_

2-Deburr as required

**DAS**  
**23**  
**9-89**

14-10-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

## Memo

0.00

QC

## Quality Control

**DAS**  
**23**  
**9-89**

14-10-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Setup Start \*NS1\*

Stop \*NS2\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.**  
**Stamp**

## Quality Control

OCT 27 2014

Brake NC

**DAS**  
**36**  
**9-89**

14/x

14/10/27

0.00

14

**DAS**  
**38**  
**9-89**

## Quality Control

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Training									
Transport									
Unapproved									

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**\*122301\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/14/14      **Start Qty:** 15.00      **\*15\***

**Cust Item ID:**

**Required Date:** 7/14/14      **Req'd Qty:** 15.00      **\*15\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

## Memo

0.00

## Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

**\*170\***

QC

## Memo

0.00

## Quality Control

175

QC5- Inspect part completeness to step on W/O

0.00

**\*175\***

QC

## Memo

0.00

## Quality Control

**DAS**  
**38**  
**9-89**

14-10 24

**DAS**  
**38**  
**9-89**

14-10-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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**Work Order ID 122301**

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**\*122301\***

Page 4

Item ID: D4925-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: EAPS Mounting Plate  
Start Date: 7/14/14 Start Qty: 15.00 **\*15\*** Cust Item ID:  
Required Date: 7/14/14 Req'd Qty: 15.00 **\*15\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00				14x			14/10/29
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							14/10/30
Quality Control									

mf  
14-10-30

DAS  
36  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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# Picklist Print

Monday, July 14, 2014 1:55:26 PM

Page 1

Work Order ID: 122301

**\*122301\***

Parent Item: D4925-1

**\*D4925-1\***

Parent Item Name: EAPS Mounting Plate

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A NEW ISSUE 13-08-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	751.7880		65			DAS
*M6061T6S 063*										**			23
6061-T6 .063 Sheet													9-89 14-10-25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	495.788	
M124446	3.7	
M126075	4.5	
M127006	9	
M127420	111.12	
M128054	63.468	
M128941	81	
M129636	223	
TPI	256	
M129637	256	

130096.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Training									
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 122301
<b>Description:</b> EAPS MOUNTING PLATE		<b>Part Number:</b> D4925-1
<b>Inspection Dwg:</b> D4925 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.098"	+0.004-0.001	0.099"	-		✓	Jkmo1
Ø 0.250"	+0.005-0.001	0.251"	-		✓	
1.00"	+0.030	1.00"	-		✓	
0.50"	"	0.50"	-		✓	
0.56"	"	0.56"	-		✓	
0.344"	+0.020	0.347"	-		✓	
0.688"	"	0.690"	-		✓	
1.555"	"	1.557"	-		✓	
16.697"	"	16.697"	-		T	Jkmo7
6.811"	"	6.811"	-		✓	
3.406"	"	3.406"	-		✓	
3.400"	"	3.400"	-		✓	
18.58"	+0.030	18.58"	-		T	
17.717"	+0.020	17.717"	-		T	
16.73"	+0.030	16.73"	-		T	
16.14"	"	16.14"	-		T	
26.14"	"	26.14"	-		T	

<b>Measured by:</b> DAS 23 9-89 <b>Date:</b> 14-10-25		<b>Audited by:</b> DAS 38 9-89 <b>Date:</b> OCT 27 2014		<b>Preliminary Approval:</b> <b>Date:</b>	
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Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4925-041	EAPS MOUNTING PLATE ASSY
1	1	D4925-1	EAPS MOUNTING PLATE
2	6	MS21059L3	NUTPLATE
3	12	MS20426AD3-4	RIVET, CSK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 122301 MWS  
14-07-15

D4925-1 EAPS MOUNTING PLATE

RELEASED  
2014-06-16

# **D4925-041 EAPS MOUNTING PLATE ASSY**

C	REMOVE SLOTS (5 PL) AND EDGE SCALLOP DETAIL	DB	14.04.04
B	COMPLETE RE-DESIGN, SEE REV A FOR DETAILS	DB	14.01.15
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4925	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	14.04.04	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4925-041" PER QSI 044 6.1
- 7) WEIGHT: 0.32 LBS

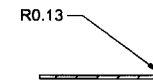
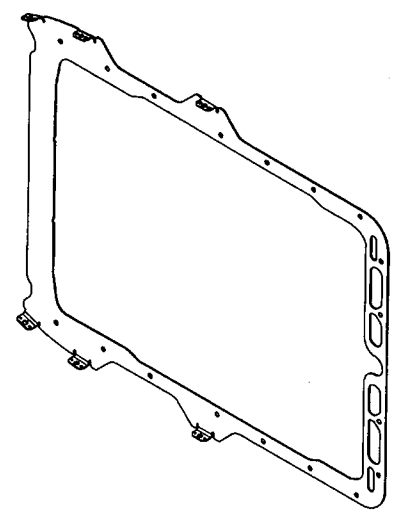
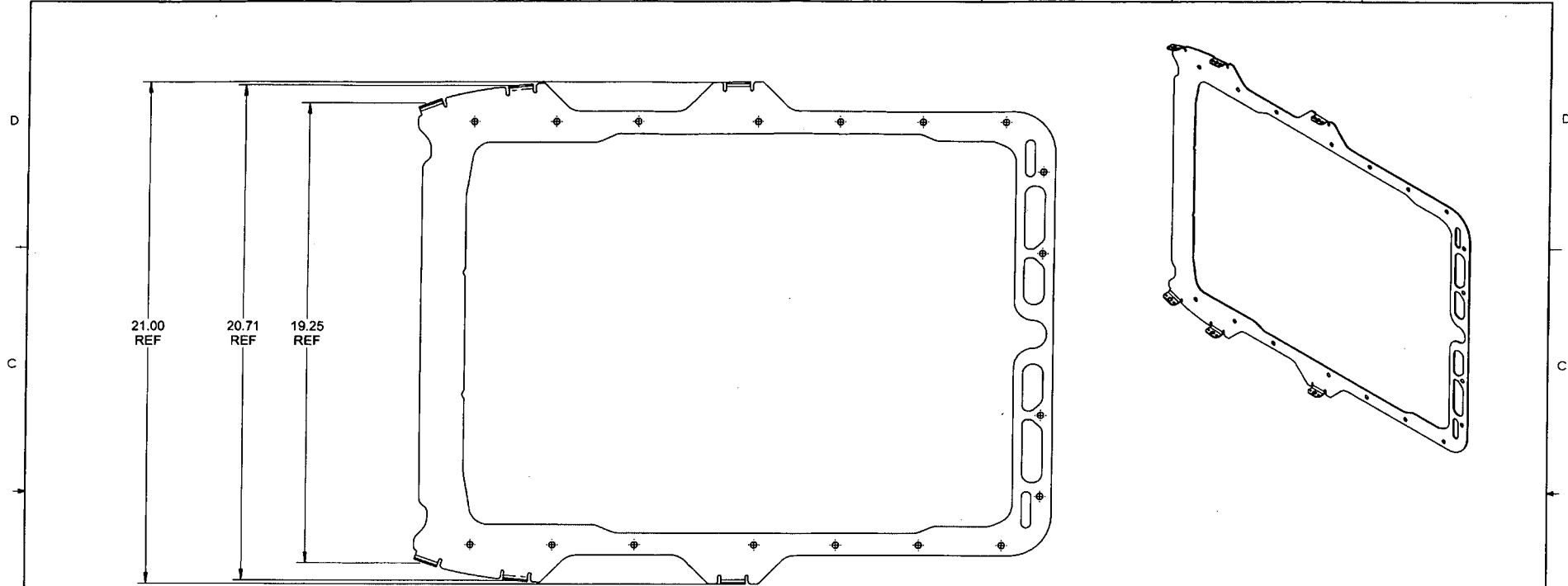
MS21059L3 NUTPLATE

MS20426AD3-4 RIVET  
2X

MASK THREADS BEFORE  
POWDER COATING

**DETAIL A**  
SCALE 4X  
6 PL

8 7 6 5 4 3 2 1



**SECTION B-B**  
SCALE 2X

**D4925-1 EAPS MOUNTING PLATE**  
(MAKE FROM D4925-1F)

**RELEASED**  
2014-06-16  
*W*

- NOTES:
- 1) MATERIAL: MAKE FROM D4925-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A

APPROVED

DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. <b>D4925</b>	REV. C SHEET 2 OF 3
MFG. APPR.	JLM	TITLE <b>EAPS MOUNTING PLATE</b>	SCALE NTS
APPROVED	MP		
DE APPR.	DS		
DATE	14.04.04	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

